

Date: Thursday, 8/23/2007 11:53:37 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PACKER	
Job Number	: 34249				
Estimate Number	: 11074				
P.O. Number	: N/A		Part Number	: D2974	
This Issue	: 8/23/2007 S.O. No. : N/A		Drawing Number	: D2974 REV. A	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: A	
Previous Run	: 29439		Material	: N/A	
Written By	: <u>10</u>		Due Date	: 9/5/2007	
Checked & Approved By	: <u>10/08/23</u>		Qty:		
Comment	: Est A 08.05.30 New Issue EC		0 Um:	Each	
	: Est A 06.11.20 New Issue EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S040	5052-H32 .040 Sheet
		 Comment: Qty.: 0.4200 sf(s)/Unit Total: 4.000 sf(s) 5052-H32 .040 Sheet Material: 5052 H32 sheet .040 Thick Batch <u>M104921</u>
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET SAV 07/08/25 10
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAV 07/08/25 10
4.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK SAV 07/08/28 X10
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 07/09/06 10 10
		Tumble <u>Deburr</u> → 07/09/06 10 10
		Bend as per dwg D2974 07/09/06 10 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: / /
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		<i>5 17/08/21 (10) Coatings</i>
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		<i>PF 07-09-24</i>
8.0	POWDER COATING	POWDER COATING  <i>M104846</i>
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		<i>M-1 07/09/24</i>
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>M 07-09-25</i>
10.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock <i>5755</i> Location: <i>57198</i>		<i>GP 07/09/25 (10)</i>
11.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		<i>70109/25</i>
Job Completion		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

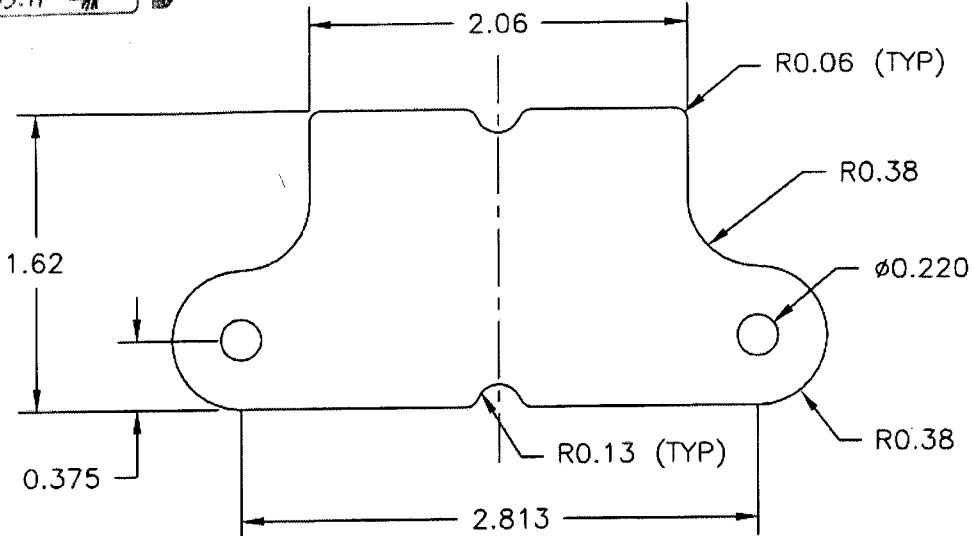


1 COPY ISSUED

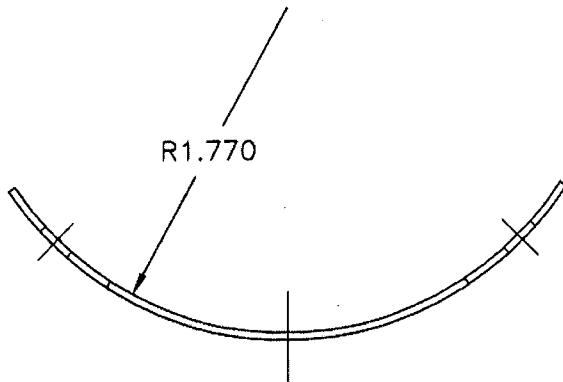
DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2974	REV. A SHEET 1 OF 1
DATE 00.03.15		TITLE PACKER	SCALE 1:1
A	00.03.15	NEW ISSUE	

RELEASED
00.05.11 *[initials]*

FLAT PATTERN



BENDING DETAIL



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *34249*

BREAK ALL SHARP EDGES 0.010 TO 0.020

MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) 0.040 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	34249
Description: Packer	Part Number:	D2974
Inspection Dwg: D2974 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	SAD	Audited by:	EN	Prototype Approval:	W/A
Date:	07/07/25	Date:	07/08/28	Date:	W/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	